

Date: Thursday, 3/8/2007 1:21:00 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPAD
Job Number	: 31134		
Estimate Number	: 12782		
P.O. Number	: N/A	Part Number	: D35643
This Issue	: 3/8/2007	Drawing Number	: D3564 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: A
Previous Run	: N/A	Material	: N/A
Written By	: <u>[Signature]</u>	Due Date	: 3/15/2007
Checked & Approved By	: <u>[Signature]</u> 07.03.08	Qty:	6 Um: Each
Comment	: Est Rev:A New Issue 07-03-08 ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	M304S16GA	304/316 .063 Sheet
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Comment: Qty.: 0.9177 sf(s)/Unit Total: 5.5062 sf(s)
 M304S16GA Stainless steel sheet 0.063" thick.
 Batch: 17106

SAD 07/03/11

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3564 ***** (D3564-1F) *****
 Dwg Rev: A
 Prog Rev: A

2-Deburr if necessary

SAD 07/03/11

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/03/11

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SAD 07/03/12 (6)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE
 Deburr if necessary
 Form on Brake as per Dwg D3564 using Jigs DT and DT
 Form Joggles (1) as per Dwg D3564 on brake using Jig DT

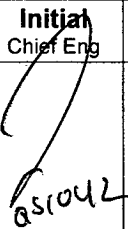


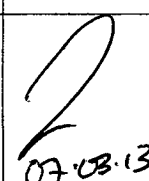
[Signature] Paul Soggle
 07-03-13

SB 07/03/13 (6)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: NO Date: 07/03/15
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/03/13	5.0	Joggle starts at 30.250° and needs to start @ 30.50. wear plates don't fit on tube. operator error.	 AS1042	Flat out the joggle and redo at 30.5 as per the Dwg.	SPB 07/03/13	 07/03/13	 AS1042	 07/03/13

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 31134

Part Number: D35643

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

07/03/13 (6)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description

Batch

A/R 2059B Hardcoat

Weld hardcoat as per Dwg D3437

M102755

FC 07 03 13 (6)

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/03/13 (6)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/03/13 (6)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

FR/M.R. 07/03/14 (6)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/03/15 (6) U

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/03/15 (6) U

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/03/15 (6)

Job Completion



07/03/15

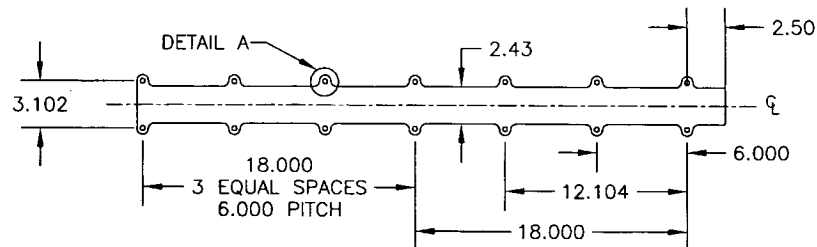
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

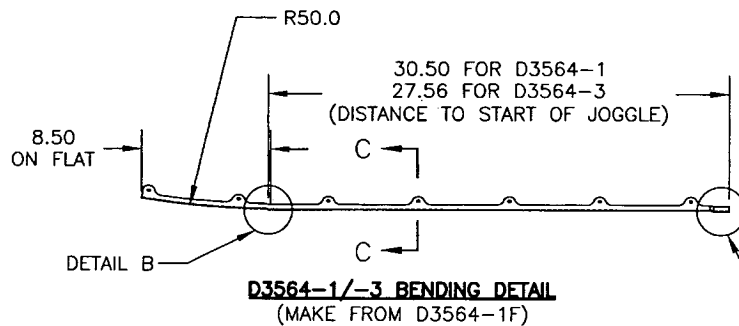
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

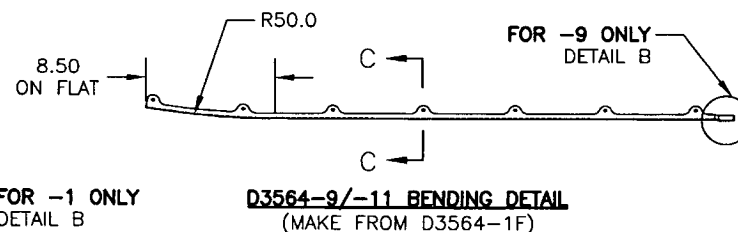
NOTE: Date & initial all entries



D3564-1F FLAT PATTERN



D3564-1/-3 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-9/-11 BENDING DETAIL
(MAKE FROM D3564-1F)

2059B HARDCOAT WELD
4.0 LONG
0.063 TO 0.125 HIGH
(TYP. 11 PLS.)
WELD AFTER BENDING AS
ILLUSTRATED PER DT8308



D3564-1/-3/-9/-11 WELDING DETAIL

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WORK ORDER
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SHOP COPY

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07-07-28

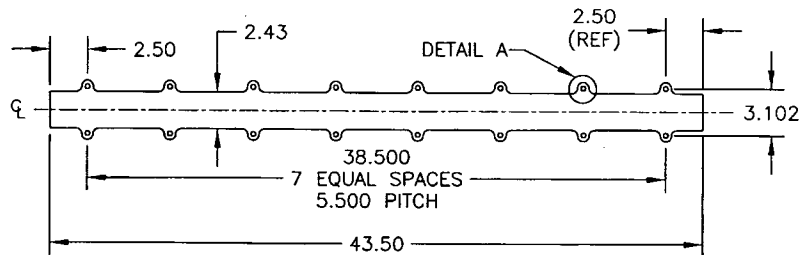
D3564-1/-3/-5/-7/-9/-11/-13 WEARPLATE NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 7) PART IS SYMMETRICAL ABOUT CENTERLINE

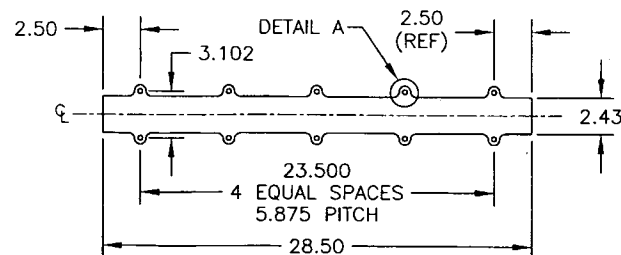
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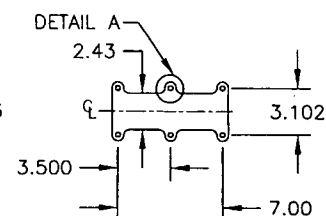
A	06.12.18	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3564
DATE	06.12.18	TITLE WEARSHOE
		REV. A SHEET 1 OF 2 SCALE 1:8



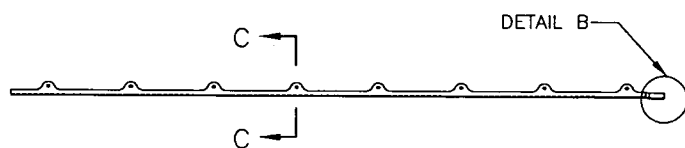
D3564-5F FLAT PATTERN



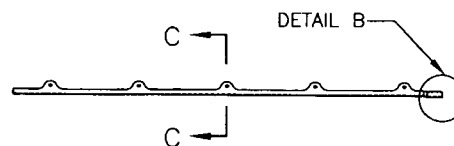
D3564-7F FLAT PATTERN



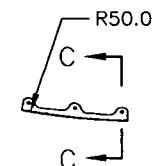
D3564-13F FLAT PATTERN



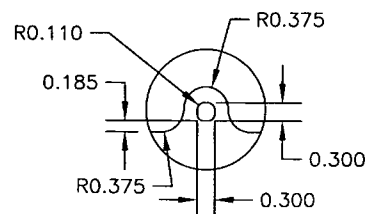
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



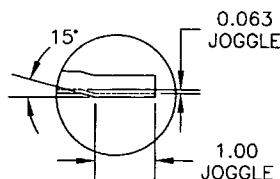
D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



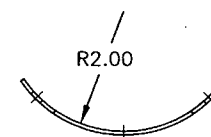
D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



DETAIL A
SCALE 1:2



DETAIL B
SCALE 1:2



SECTION C-C
SCALE 1:2

RELEASED
07 02-28

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DATE 06.12.18		TITLE WEARSHOE	SCALE 1:8

